

**Work Order ID 53465**

Page 1

November 6, 2009 8:23:18 AM

Item ID: D2857-2

Accept



Setup

Start



Revision ID: B

Stop



Item Name: Hinge Bracket

Start Date: 05/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: *[Signature]*Date: *09/11/15* Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2857	Rev B

100



BAND SAW

0.00

*12*

Bandsaw

Memo

0.00

*JL 09/11/19*

Jeaspa Bandsaw

Cut blanks 5.2"

110



HAAS CNC VERTICAL MACHINING #1

0.00

*12*

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio D2857-2□2-Deburr any rough edges

*DT 09/11/20  
H.A 09/11/21*

120



QC2- Inspect parts off machine FAI/FAIB

0.00

*12*

QC

Memo

0.00

Quality Control

*DT 09/11/20*

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00

Shawn/11/22

12



QC

Quality Control

Memo

0.00

140

Chemical Conversion Coat per QSI005 4.1

0.00

All over 11/23



HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

BK 09-11-23



QC

Quality Control

Memo

0.00

(12)

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Customer:

**Reference:**

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description**Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

11/11/23 12 9

Powdercoat

M112148

Powder Coating

Memo

0.00

09/11/23

170



QC3- Inspect Part Finish

0.00

BR 09-11-23

QC

Quality Control

Memo

0.00

180



Identify as per dwg &amp; Stock Location: 52

0.00

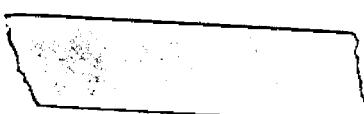
9/11/24 12x

Packaging

Memo

0.00

Packaging



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Stop



Item Name: Hinge Bracket

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Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/11/25 JJ

PL 09-11-24  
(12)

# Picklist Print

Page 1

November 6, 2009 8:23:22 AM

Work Order ID: 53465



Parent Item: D2857-2RevB



Parent Item Name: Hinge Bracket

Start Date: 05/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased		No		100	f	30.8000	5.5263			

6061-T6 Bar 2.00 x 1.25



Warehouse                    Loc Qty                    Loc Code

Location

Main Warehouse

MAT

30.8

105838

12

110936

18.8

5.526

SL 09/11/09

DART AEROSPACE LTD	Work Order:	53465
Description: Hinge Bracket	Part Number:	D2857-2
Inspection Dwg: D2857 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.310	✓			
4.000	+/-0.010	4.005	✓			
0.340	+/-0.010	0.340	✓			
1.110	+/-0.005	1.108	✓			
1.790	+/-0.010	1.790	✓			
1.320	+/-0.005	1.320	✓			
2.000	+/-0.010	2.002	✓			
0.340	+/-0.010	0.340	✓			
0.447	+/-0.010	0.447	✓			
Ø0.171	+0.005/-0.000	0.173	✓			
0.147	+/-0.010	0.139	✓			
0.376	+/-0.010	0.378	✓			
0.126	+/-0.010	0.125	✓			
0.063	+/-0.010	0.069	✓			
Ø0.166	+0.005/-0.000	0.1665	✓			
0.911	+/-0.010	0.910	✓			
0.600	+/-0.010	0.600	✓			
0.125	+/-0.010	0.126	✓			
0.150	+/-0.010	0.148	✓			

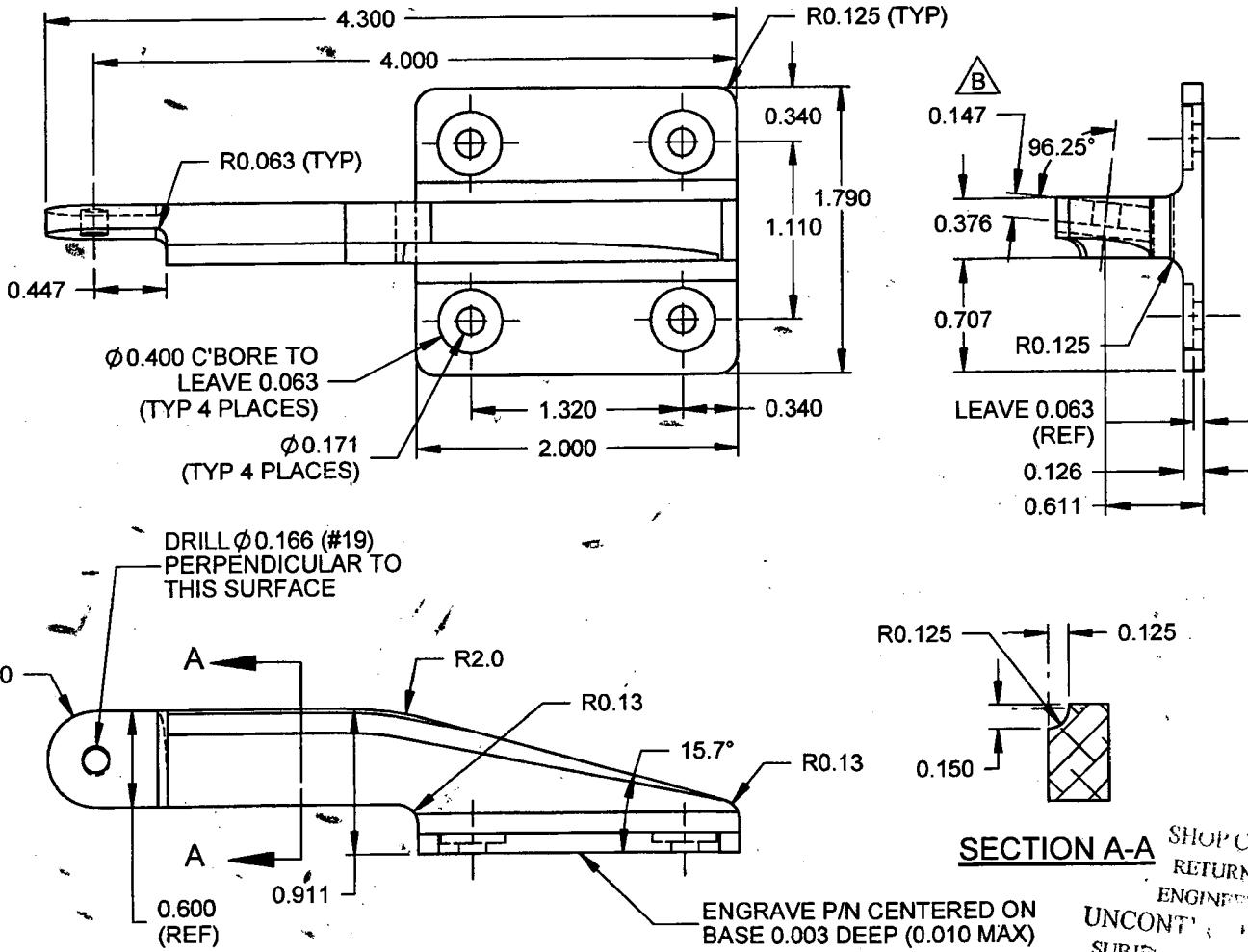
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	09/11/20	Date:	09/11/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	

**DART**

DESIGN KE	DRAWN BY <i>CE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. <b>D2857</b>
DATE <b>06.08.28</b>		REV. B SHEET 1 OF 1
		TITLE <b>HINGE BRACKET</b>

REV	DATE	DESCRIPTION
A	98.12.14	NEW ISSUE
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS

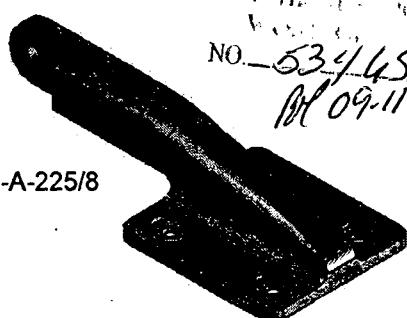
**RELEASED**  
06-10-13**D2857-1 HINGE BRACKET**  
**D2857-2 OPPOSITE**

SECTION A-A      SHOP CUT  
                  RETURN TO  
                  ENGINEERING  
UNCONT'D  
SUBJ:

NO. 53445  
BL 09.11.0

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8  
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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